

Work Order ID 51088

July 30, 2009 3:27:55 PM



Page 1

Item ID: D3826-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rib / Gusset Assembly

Start Date: 07/31/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 08/05/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *See pg. 2*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on rib and weld as per dwg D3826 A/R ER316 S.S. Rod
Batch: *M-109213*

CP 09.08.04

(6)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.08.04

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8/09/08/04

(16)

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51088

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Item ID:	D3826-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Rib / Gusset Assembly					
Start Date:	07/31/2009	Start Qty:	6.00		Cust Item ID:	
Required Date:	08/05/2009	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>09-07-30</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <i>Basket</i>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

1D 09.07.04 6

u gusset

10508.07
ls

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 51088

Parent Item: D3826-041RevB

Parent Item Name: Rib / Gusset Assembly

Start Date: 07/31/2009

Required Date: 08/05/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1RevB1		Manufactured	No				Each	15.0000	6.0000			
Basket Rib												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

15

50565

5

50822

10

Each

4.0000

6.0000

2 Ppl 09.07.30
4 Ppl 09.07.30

D3929-041RevA

Manufactured

No



Gusset Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

4

47273

1

50566

3

Each

5.0000

6.0000

3 Ppl 09.07.30

3 Ppl 09.07.30

D3929-042RevA

Manufactured

No



Gusset Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

50567

5

*

50869

50869 Ppl 09.07.30

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

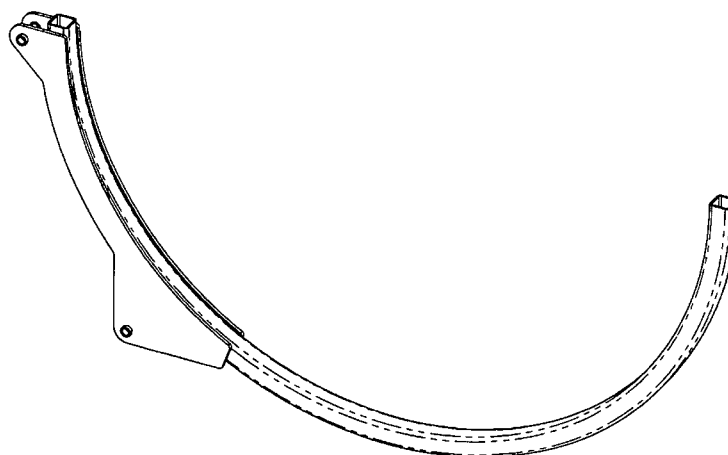
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NOTE: Date & initial all entries

UNF 09-07-31
51088.

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△



D3826-041 RIB/GUSSET ASSY

RELEASED
5/10/12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.32 lbs

△

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3826
REV. B
SHEET 1 OF 2
TITLE RIB/GUSSET ASSY
SCALE NTS

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NOTE: Date & initial all entries

MF w/051088
09-09-31

B D3929-042
GUSSET ASSEMBLY

B D3929-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

RELEASED
8/16/12

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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